

09/695874

ABSTRACT

A method of manufacturing the caliper body of a vehicular disc brake by the gravity casting method. The caliper body is used for the vehicular disc brake wherein a pair of frictional pads are disposed opposite to each other with a disc rotor held therebetween. The caliper body has a cylinder disposed on one side of the disc rotor, a reaction pawl disposed on the other side of disc rotor, and a bridge for coupling the cylinder and the reaction pawl on the outer peripheral side of the disc rotor.

10 A sprue is provided in the bottom portion of the cylinder, and the caliper body is cast by a cavity with the side of molding the bottom portion of the cylinder disposed in the upper part of and in the vertical direction of the cavity and with the side of molding the reaction pawl disposed in the lower part of and
15 in the vertical direction thereof. Accordingly, it is possible to make a product stable in quality by the gravity casting method, the product having sufficient rigidity as the caliper body of a vehicular disc brake.